

Thursday, 11/24/2005 1:39:25 PM
Linda Lacelle

Process Sheet

Split X 42

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FWD TUBE ASSEMBLY
Job Number : 24865	
Estimate Number : 10467	
P.O. Number : N/A	Part Number : D3391021
This Issue : 11/24/2005 S.O. No. : N/A	Drawing Number : D3391 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 24865	Material : N/A
Written By : <i>SEE COMMENT BELOW</i>	Due Date : 12/20/2005 Qty: 5 Um: Each
Checked & Approved By : <i>SEE COMMENT BELOW</i>	
Comment : Est. A 05.09.13 New Issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6013047	SKIDTUBE MAT'L
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

SKIDTUBE MAT'L

Pick:

Qty	Part Number	Description	Batch
1	D6013-047	Extrusion	323935

ml 05/11/28 5

2.0	LANDING GEAR 1 Band saw	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1 Band saw

Cut extrusion to 46.52 +0.010 -0.020

ml 05/11/28 5

3.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Bend as per Dwg D3391

DP/B 05-12-15

(10)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

20512-23 10

5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA590 Rev. C & Dwg D3391 Rev. C
Identify as D3391-1

2-Deburr

SD 06-01-05

9

(10)

(10)

day, 11/24/2005 1:39:25 PM
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Process Sheet

Order: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 24865

Part Number: D3391021

Job Number:



Seq. #: Machine Or Operation:

Description:

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 06-01-05

(10)

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

206-01-19

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Drill and c/sink float bag holes as per Dwg D3391 using DT8798 DP06-1-7 (2)

Drill wearplate holes as per Dwg D3391 DP06-1-7 (2)

Deburr DP06-1-7 (2)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1 DP06-1-7 (2)

DL 06/04/13

(1)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/07/15

(1)

FC 06 01 25

DL 06/04/13

(1)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 07 15

FC 06 07 15

(1)

12.0

D3401041

Tow Cap Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Tow Cap Assembly

Pick:

Qty

Part Number

Description

Batch

1

D3401-041

Tow Cap

24487

B25548

Bolt

DL 06/07/15

(1)

FC 06 01 25

DL 06/04/18

(1)

13.0

AN3C4A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Bolt

Pick:

FC 06 01 25

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Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 24865

Part Number: D3391021

Job Number:



Seq. #:	Machine Or Operation:	Description:
	Qty Part Number Description Batch	
	4 AN3C4A Bolt M190651 (4)	DL 06/07/16
14.0	NAS1330C3KB166 Rivnut M19185 M19522	DL 06/04/18 FC 06 01 25



Comment: Qty.: 24.0000 Each(s)/Unit Total: 120.0000 Each(s)

Rivnut

Pick:

Qty

24

Part Number

NAS1330C3KB166

Description

Insert

Batch

M19354

M18308

DL 06/07/16 (1)
FC 06 01 25

DL 06/04/18

15.0

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Washer

Pick:

Qty

4

Part Number

NAS1515H3L

Description

Washer

Batch

M17450

M19185

DL 06/07/16 (1)
FC 06 01 25

DL 06/04/18 (1)

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install inserts and Tow Cap as per Dwg D3391

Identify as D3391-021

DL 06/07/16 (1)
DL 06/04/18 (1)
FC 06 01 25
M 06 01 31

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

19.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SAC 06/02/07 (2)

DL 06/07/18

DL 06/02/06

Job Completion



DL 06.07.31

DL 06/04/18

4

AN960C10L

Washer

M18822

DL 06/04/18

